Date:	Tuesday, 11/6/2007 1:26:07 PM			y		1	/_
User:	Kim Johnston	Proce	ess Sheet			- 1)	
Customer Job Number Estimate Nur P.O. Number This Issue Prsht Rev. First Issue Previous Rur Written By Checked & A Comment	mber : 10296 r : N\A : 11/6/2007	epters Services : NACHINED PARTS 200 // 07 New Issue 05-11-06 JLM	Part Number Drawing Number Project Number Drawing Revision Material Due Date	: DOUBLER : D32203 : D3220 REV A1 : N/A : A1 : 11/16/2007	Qty:	8 Um: E	Each
					-		
Job Number:			•				
Seq. #:	Machine Or Operation:	1000	Description :				
1.0		2024-T3 .0					
(Comment: Qty.: 0.6233 sf(s)/U	Unit Total: 4.9862 sf(s)		•			
	•	Q-A-250/4) 0.050" thick	- B		8)	
2.0	WATER JET		ATER JET				
3.0	Comment: FLOW WATER JET	INSPECT	PARTS AS THEY COME	OFF MACHINE			
	Comment: INSPECT PARTS AS	B 07-11.	- 8	OFT MACE III VE			
4.0		SECOND	СНЕСК		La ca	ruls	
	Comment: SECOND CHECK		V 14/11	107 ((2)	· · ·	
5.0			NISHING RESOURĆE #1				
١	Comment: HAND FINISHING RE Chemical Conversion	ESOURCE #1 Coat as per QSI 005 4.1	MJ	NI-1	(-(7	Sel	
6.0			POWDER COAT/CHEMIC	CAL CONVERSION			
С	Comment: INSPECT POWDER (COAT/CHEMICAL CONVERSI	ION ///	11.1.	01/	11/12	
				- /u			

Dart Aerospace Ltd

Duitho	.copace Lta							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCR: Y	es No DQ	A: 1	Date: ⊆	57/11/14
				Q	A: N/C Close	ed:	Date:	
NCP:			WORK ORDER NON-COM	FORMANCE (N	CR)	·····		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC		Corrective Action Section B			Approval Chief Eng			
		Section A	Initial Action Description Sign & Chief Eng Date		Verification Section C	Approval QC Inspecto				
		·								
				4		1		1		

NOTE: Date & initial all entries

Dąte:

Tuesday, 11/6/2007 1:26:07 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35568D

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

57234 Location:___





8.0

QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 87.11.13

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Dait Ac	Tospace	Ltu				*				
W/O:			WC	RK ORDER CHAN	NGES					
DATE	STEP	PROC	EDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·							
Part No		PAR #:	_ Fault Cateo	jory:	NCI	R: Yes	No DQ	A :	_ Date: _	
						QA: N	C Closed	d:	_ Date: _	
NCR:		W	ORK ORDE	R NON-CONFORI	MANCE	(NCR)			
DATE	STEP	Description of NC			ection B		- Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Section		Chief Eng	QC Inspector
					:					
							-	:		
							1			1

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35568P
Description: Doubler	Part Number:	D3220-3
Inspection Dwg: D3220 Rev: A1		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
	X First Article Prototype									
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments				
Dimension	- Paradaria	Dimension			mspection					
6.94	+/-0.030	6.942	×							
12.32	+/-0.030	12.32	74							
R0.20	+/-0.030	عد.	X							
0.050 thick	+/-0.005	,681	×							
Grain Direction	N/A									

	,									
			·							
		·								

Measured by: LB	Audited by:	۵	Prototype Approval:	N/A
Date: 01-11-8	Date:	Alula	Date:	N/A

Rev	Date	Change		Revised by	Approved
A 0	04.02.27	New Issue	P/O D412-698-013	KJ/RF	



DESIGN TRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
	CHECK	KED AL	APPROVED	DRAWING NO.	REV. A	
		#	#F	D3220	SHEET 1 OF 2	
	DATE			TITLE	SCALE	
	03.1	10.16		DOUBLER	1:2	
	Α		03.10.16	NEW ISSUE		

CORRECTED DIM

14.25 -5.50 **-** 7.000 **-**MS21059L4 NUTPLATE (1) MS20426AD3-4 RIVET (2) (4 PLACES) 1.50 1.000 7.00 0.500 (TYP) -1.000 (TYP) **GRAIN** po.316 'O' DRILL (Ø0.323) D3220-1 DOUBLER (TYP 4 PLACES) R0.50 (TYP) DRILL #40 (Ø0.098) C'SINK Ø0.180x100° OTHER SIDE (TYP 8 PLACES)

03.11.13

D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER) PCOPY RETURN TO

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.090)

ENGINEERING

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

UNCONTROLLED COPY SUBJECT TO AMENDMENT

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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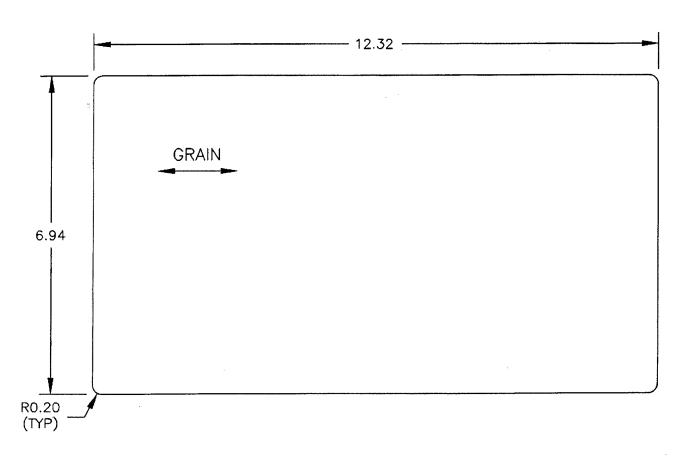
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CHECKED	APPROVED,	DRAWING NO.	REV. A
#	#	D3220	SHEET 2 OF 2
DATE		TITLE	SCALE
03.10:16		DOUBLER	1:2





D3220-3 DOUBLER

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK

(REF DART SPEC. M2024T3S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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